

counted  
xii

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 73821



Page 2

Friday, September 16, 2011 10:50:06 AM

Item ID: D3413-1	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Ring					
Start Date: 9/16/2011	Start Qty: 80.00		Cust Item ID:		
Required Date: 10/14/2011	Req'd Qty: 80.00		Customer:		
Reference:					

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	Small Fab	0.00							
Small Fab	Memo	0.00							
Small Fab	1- Deburr and drill hole if required as per dwg D3413 & QSI018 4.1 .								

*EP 11/10/03* *(40)*

140	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

*QC5*  
*(40)*

150	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>8:40</i>		OVEN TEMPERATURE:						
	FINISH TIME:								

*41 x Ø m 11/10/06*

*M 11/8439* *40001* *9:10*

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**Work Order ID 73821**

Friday, September 16, 2011 10:50:06 AM



Page 3

Item ID: D3413-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Ring

Start Date: 9/16/2011 Start Qty: 80.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 80.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

41 BR 11-10-6

170

Identify as per dwg &amp; Stock Location: ST 308 0.00



Packaging

Memo

0.00

Packaging

(41x) SP 11-10-6

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

n100/110  
mc  
11-10-6

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# Picklist Print

Friday, September 16, 2011 10:50:03 AM

Page 1

Work Order ID: 73821

Parent Item: D3413-1

Parent Item Name: Ring



Start Date: 9/16/2011

Required Date: 10/14/2011

Start Qty: 80.00

Required Qty: 80.00

Comments: IPP Rev:A 05.09.13 New issue KJ/JLM  
IPP Rev:B Now on Waterjet 07-05-28 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304B0.250X4.000		Purchased	No			100	f	13.0000	0.25	21.05263			
304 BAR .250 x 4.00													

IBH-9-22

Location

Loc Qty

Loc Code

MAT009

13

118182

13

118182

(41)

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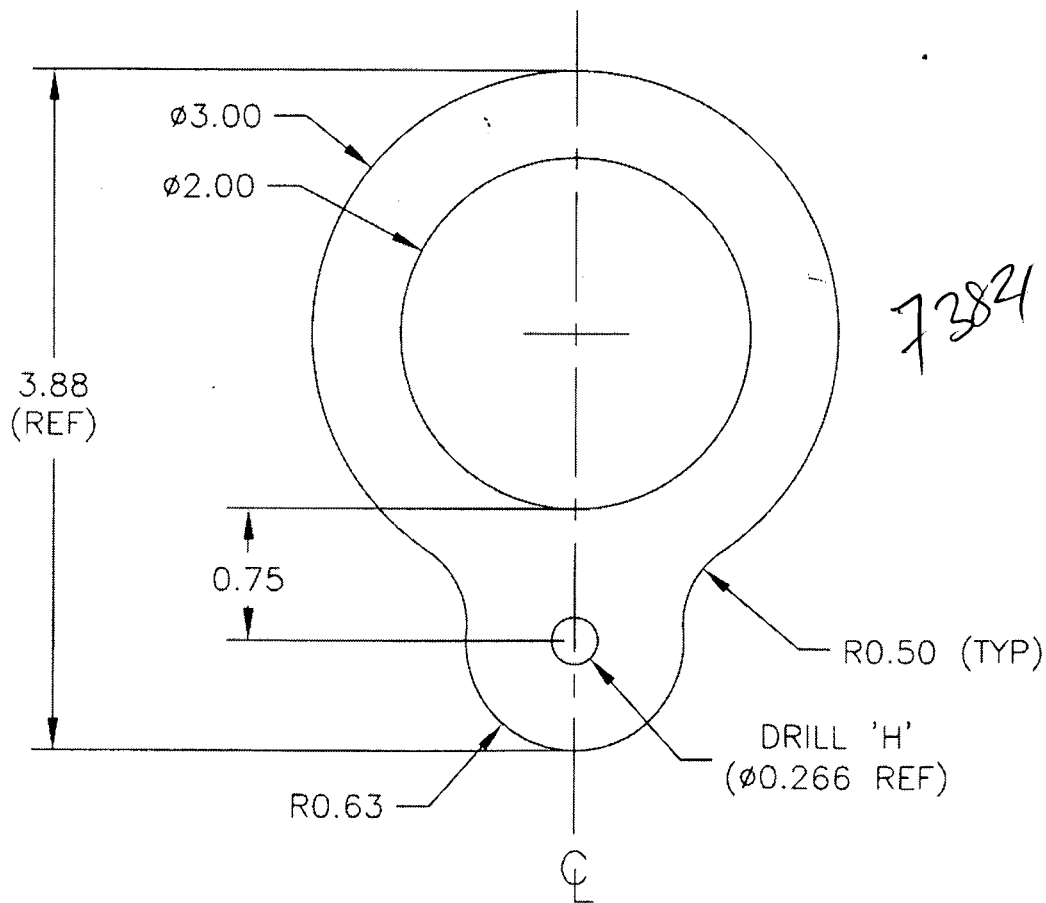
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DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3413	REV. A SHEET 1 OF 1
DATE 05.03.16		TITLE RING	SCALE 1:1
A	05.03.16	NEW ISSUE	



### D3413-1 RING

- 1) MATERIAL: AISI 304/316 SS PLATE, 0.250 THICK (REF DART SPEC. M304S3GA)
- 2) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) DEBURR ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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